

Work Order ID 55201

January 11, 2010 3:48:23 PM



Page 1

Item ID: D3684-043

Accept



Setup Start



Revision ID:

Item Name: MOUNT ASSEMBLY

Stop



Start Date: 1/12/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 1/19/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 10/01/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3684

Rev C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SB 10/01/26

(3)

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684 2-Assemble D3684-049 & D3687-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684 ***Ensure holes for AN3C Bolts are free

SB 10/01/26

(3)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 10/01/26

(x3)

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January 11, 2010 3:48:23 PM



Page 2

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

Packaging

10-1-26 SF 34

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/27 JD

MF 10-1-27

Picklist Print

January 11, 2010 3:48:22 PM

Page 1

Work Order ID: 55201

Parent Item: D3684-043

Parent Item Name: MOUNT ASSEMBLY

Comments: IPP Rev:A new issue 08-02-12 DD verified by:LL
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Start Date: 1/12/2010

Required Date: 1/19/2010

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN3C12A		Purchased	No			110	Each	346.0000	12.0000			
												
Bolts												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

346

112314

346

D3684-047

Manufactured No

110 Each 0.0000 3.0000



FWD LEG ASS'Y

B S4875

D3684-049

Manufactured No

110 Each 4.0000 3.0000



AFT LEG ASS'Y

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

4

45601

1

48169

3

12 8B 10/01/24

8B 10/01/26

3 8B 10/01/26

Picklist Print

January 11, 2010 3:48:23 PM

Page 2

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Parent Item: D3684-043



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Required Date: 1/19/2010

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Start Qty: 3.00

Required Qty: 3.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3687-1		Manufactured	No			110	Each	9.0000	3.0000			
MOUNT												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3

46760

3

Main Warehouse

ST118

6

51097

6

D3692-1

Manufactured No

110

Each

638.0000

24.0000



SPACER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

55

44827

8

45672

14

50325

33

Main Warehouse

ST127

583

50736

175

51467

408

2

1

Sp 10/01/26

27

Sp 10/01/26

January 11, 2010 3:48:23 PM

Shop Packet Print

Page 2

Picklist Print

January 11, 2010 3:48:23 PM

Page 3

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Start Qty: 3.00

Required Qty: 3.00

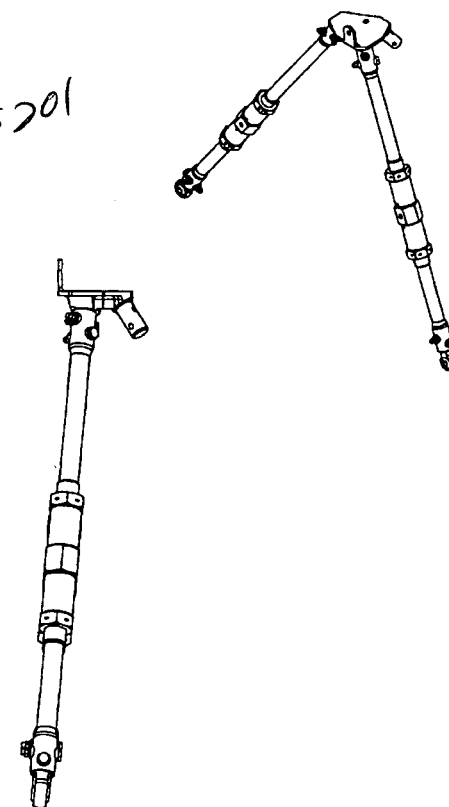
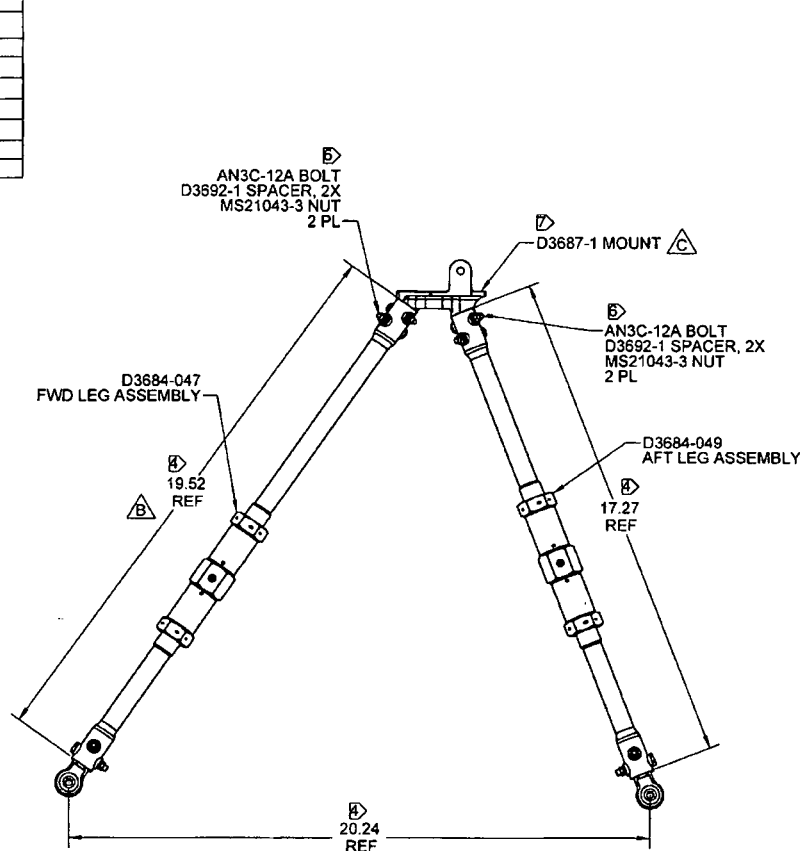
Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21043-3		Purchased	No			110	Each	4,480.000	12.0000			
Nut												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	80	
103691	80	
Main Warehouse		
ST	4400	
111819	70	
112243	29	
112314	4301	

Sp 10/6/26

12

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D3684-043	MOUNT ASSEMBLY
2	1	D3687-1	MOUNT
3	1	D3684-047	FWD LEG ASSY
4	1	D3684-049	AFT LEG ASSY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



D3684-043 MOUNT ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-043 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	GP	DRAWING NO.	REV. C
MFG. APPR.	21	D3684	SHEET 2 OF 5
APPROVED	14	TITLE	SCALE
DE APPR.	14	TRIPOD MOUNT ASSY	NTS
DATE	08.12.15	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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07/01/12